

Work Order ID 85251

June-05-12 9:11:30 AM

\*85251\*

Page 1

Item ID: D412-742-043

Accept

Revision ID:

Item Name: Replacement Float Skidtube

Start Date: 05/06/2012 Start Qty: 1.00 \*1\*

Required Date: 19/06/2012 Req'd Qty: 1.00 \*1\*

Reference:

Approvals: Process Plan: MLJ Date: 12/06/05 Tooling:  
QC: Date: SPC (Y/N):

\*N900040100\*

Setup

Start

\*NS1\*

Stop

\*NS2\*

Cust Item ID:

Customer:

Run

Start

\*NR1\*

Stop

\*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3391	I								
100		0.00							
*100*	DOCUMENT CONTROL								
DC	Memo	0.00							
Document Control	If D412-742-043 is a W/O on its own, Photocopy bluefile and create labels per PPP D412-742-043 CHG005								

N/A *[Signature]*

385251



**Work Order ID 85251**

June-05-12 9:11:30 AM

**\*85251\***

Page 3

Item ID: D412-742-043

Accept

**\*N900040100\***

Setup

Start

**\*NS1\***

Revision ID:

Item Name: Replacement Float Skidtube

Start Date: 05/06/2012 Start Qty: 1.00 **\*1\***Required Date: 19/06/2012 Req'd Qty: 1.00 **\*1\***

Cust Item ID:

Customer:

Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

Run

Start

**\*NR1\***

QC:

Date:

SPC (Y/N):

Date:

Stop

**\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID

Tool #

Plan  
CodeAccept  
QtyReject  
QtyReject  
NumberInsp.  
Stamp

120

**\*120\***

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

5/26/03

130

**\*130\***

Packaging

Packaging

0.00

IX

Packaging

Memo

0.00

Identify and pack for shipping as per PPP D412-742-043

Location:

PPP Rev: E

140

**\*140\***

QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

12/7/03

Memo

0.00

MF  
12-07-04

## Picklist Print

June-05-12 9:11:33 AM

**Work Order ID:** 85251

**Parent Item:** D412-742-043

**Parent Item Name:** Replacement Float Skidtube

\*85251\*  
\*D412-742-043\*

**Start Date:** 05/06/2012

**Required Date:** 19/06/2012

Start Qty: 1.00

**Required Qty:** 1.00

**Comments:** IPP Rev A 05.10.13 New Issue KJ/JLM  
IPP Rev 06.02.13 ECN 773 dwg @ rev.D EC  
IPP Rev:C 07-05-28 As per Rev F JLM  
IPP Rev:D 07-12-04 ECN 1072 DD verified by:JLM  
IPP Rev:E 08-09-08 ecn 08-510 DD verified by:EC IPP  
11.11.01 as per DS19517 REV.B DD verified by:EC

NCR: Yes / No

DQA: \_\_\_\_\_ Date: \_\_\_\_\_

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS							
			Rework Scrap Use-as-is Work Order Update	<input type="checkbox"/>	Skid-tube Machining Thermoforming Large Fab	<input type="checkbox"/>	Crosstube Small Fab Finishing Composite	<input type="checkbox"/>	Prod. Eng. Coor. Rec/Store/Packaging Supplier Other	<input type="checkbox"/>	Engineering Quality	<input type="checkbox"/>
Part No. _____												
NCR No. _____												
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance		Initial Chief Eng	Action Description		Sign & Date	Verification	QC Inspector	
Doc/Data												
Equip/Tooling												
Operator												
Material												
Offset/Setup												
Other												
Process												
Supplier												
Training												
Unauthorized												
FAULT CATEGORY												
<b>Landing Gear</b> <input type="checkbox"/> Bending Passes Below Min <input type="checkbox"/> Centre Not Concentric to O/S <input type="checkbox"/> Cracks <input type="checkbox"/> Crushed/Crimp at Bending <input type="checkbox"/> Inspection Strip in Tube <input type="checkbox"/> Other <input type="checkbox"/> Positioned Wrong <input type="checkbox"/> Ripples on Inner Bend <input type="checkbox"/> Torque Waves in Extrusion <input type="checkbox"/> Turning Sequence <input type="checkbox"/> Wave/Twist in Tube				<b>Hardware</b> <input type="checkbox"/> Breaking <input type="checkbox"/> Missing <input type="checkbox"/> Size/Length <input type="checkbox"/> Spinning <input type="checkbox"/> Threading <input type="checkbox"/> Wrong		<b>General</b> <input type="checkbox"/> Burrs <input type="checkbox"/> Contamination <input type="checkbox"/> Cut Too Short <input type="checkbox"/> Documentation/Data <input type="checkbox"/> Finish <input type="checkbox"/> Inspection Incomplete <input type="checkbox"/> Inspection Unqualified <input type="checkbox"/> Instructions Incomplete/Unclear <input type="checkbox"/> Jigs/Fixtures/Tooling <input type="checkbox"/> Kit Incorrect <input type="checkbox"/> Kit Missing		<input type="checkbox"/> Maintenance <input type="checkbox"/> Mislabeled <input type="checkbox"/> Off-Set <input type="checkbox"/> Orientation Misread <input type="checkbox"/> Out of Calibration <input type="checkbox"/> Out of Sequence <input type="checkbox"/> Outside Dimensions <input type="checkbox"/> Over/Under tolerance <input type="checkbox"/> Part Lost <input type="checkbox"/> Part Moved <input type="checkbox"/> Raw Material				
								<input type="checkbox"/> Set-up <input type="checkbox"/> Supplier <input type="checkbox"/> Temperature/Cure <input type="checkbox"/> Weld <input type="checkbox"/> Wrong Stock Pulled				
								<input type="checkbox"/> Other				

# Picklist Print

June-05-12 9:11:33 AM

Page 2

Work Order ID: 85251

Parent Item: D412-742-043

Parent Item Name: Replacement Float Skidtube

**\*85251\***  
**\*D412-742-043\***

Start Date: 05/06/2012

Start Qty: 1.00

Required Date: 19/06/2012

Required Qty: 1.00

AN3C6A

Purchased

No

110

Each

451.0000

10

10

\*\*

*Hl 1206128*

**\*AN3C6A\***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FP001	1	
111982	1	
ST351	450	
111982	2	
116419	23	
116549	2	
116704	12	
117619	10	
117688	1	
117872	5	
118422	13	
119449	21	
120423	3	
120693	158	
<u>121682</u>	200	

AN3C7A

Purchased

No

110

Each

140.0000

4

4

\*\*

*Hl 1206128*

**\*AN3C7A\***

BOLT

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	140	
113149	14	
116169	1	
117313	10	
117619	12	
117688	6	
119749	1	
120731	8	
<u>121185</u>	50	
121541	38	

NCR: Yes / No

DQA: Date:

## WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: \_\_\_\_\_ Date: \_\_\_\_\_

Work Order: _____			DISPOSITION		AGAINST DEPARTMENT/PROCESS					
Part No. _____			Rework <input type="checkbox"/>	Skid-tube <input type="checkbox"/>	Crosstube <input type="checkbox"/>	Prod. Eng. Coor. <input type="checkbox"/>	Engineering <input type="checkbox"/>			
NCR No. _____			Scrap <input type="checkbox"/>	Machining <input type="checkbox"/>	Small Fab <input type="checkbox"/>	Rec/Store/Packaging <input type="checkbox"/>	Quality <input type="checkbox"/>			
			Use-as-is <input type="checkbox"/>	Thermoforming <input type="checkbox"/>	Finishing <input type="checkbox"/>	Supplier <input type="checkbox"/>				
			Work Order Update <input type="checkbox"/>	Large Fab <input type="checkbox"/>	Composite <input type="checkbox"/>	Other <input type="checkbox"/>				
Root Cause	Date	Step	Qty	Description of work order update or Non-conformance	Initial Chief Eng	Action Description	Sign & Date	Verification	QC Inspector	
Doc/Data										
Equip/Tooling										
Operator										
Material										
Offset/Setup										
Other										
Process										
Supplier										
Training										
Unauthorized										
FAULT CATEGORY										
Landing Gear				Hardware		General				
Bending Passes Below Min		Breaking <input type="checkbox"/>		Burrs <input type="checkbox"/>		Maintenance <input type="checkbox"/>		Set-up <input type="checkbox"/>		
Centre Not Concentric to O/S		Missing <input type="checkbox"/>		Contamination <input type="checkbox"/>		Mislabeled <input type="checkbox"/>		Supplier <input type="checkbox"/>		
Cracks <input type="checkbox"/>		Size/Length <input type="checkbox"/>		Cut Too Short <input type="checkbox"/>		Off-Set <input type="checkbox"/>		Temperature/Cure <input type="checkbox"/>		
Crushed/Crimp at Bending		Spinning <input type="checkbox"/>		Documentation/Data <input type="checkbox"/>		Orientation Misread <input type="checkbox"/>		Weld <input type="checkbox"/>		
Inspection Strip in Tube		Threading <input type="checkbox"/>		Finish <input type="checkbox"/>		Out of Calibration <input type="checkbox"/>		Wrong Stock Pulled <input type="checkbox"/>		
Other		Wrong <input type="checkbox"/>		Inspection Incomplete <input type="checkbox"/>		Out of Sequence <input type="checkbox"/>				
Positioned Wrong				Inspection Unqualified <input type="checkbox"/>		Outside Dimensions <input type="checkbox"/>				
Ripples on Inner Bend				Instructions Incomplete/Unclear <input type="checkbox"/>		Over/Under tolerance <input type="checkbox"/>				
Torque Waves in Extrusion				Jigs/Fixtures/Tooling <input type="checkbox"/>		Part Lost <input type="checkbox"/>				
Turning Sequence				Kit Incorrect <input type="checkbox"/>		Part Moved <input type="checkbox"/>				
Wave/Twist in Tube				Kit Missing <input type="checkbox"/>		Raw Material <input type="checkbox"/>				

# Picklist Print

June-05-12 9:11:33 AM

Page 3

Work Order ID: 85251

\*85251\*

Parent Item: D412-742-043

\*D412-742-043\*

Parent Item Name: Replacement Float Skidtube

Start Date: 05/06/2012

Required Date: 19/06/2012

Start Qty: 1.00

Required Qty: 1.00

AN960C10L	<u>NAS1149C0332</u>	Purchased	No	110	Each	0.0000	38	38
-----------	---------------------	-----------	----	-----	------	--------	----	----

X1122063

\*\*

(x38) HL 1106128

\*AN960C10L \*

R

washer

D4095-041

Manufactured

No

110 Each 0.0000

1

1

\*\*

383809 (x1) HL 1106128

\*D4095-041\*

Wearplate Assembly

D4095-043

Manufactured

No

110 Each 1.0000

1

1

\*\*

HL 1106128

\*D4095-043\*

Wearplate Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP001

1

\_\_\_\_\_

81624

1

Y1

D4095-045

Manufactured

No

110 Each 15.0000

\*\*

HL 1106128

\*D4095-045\*

Wearplate Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FP

1

\_\_\_\_\_

81625

1

\_\_\_\_\_

FP001

14

\_\_\_\_\_

77737

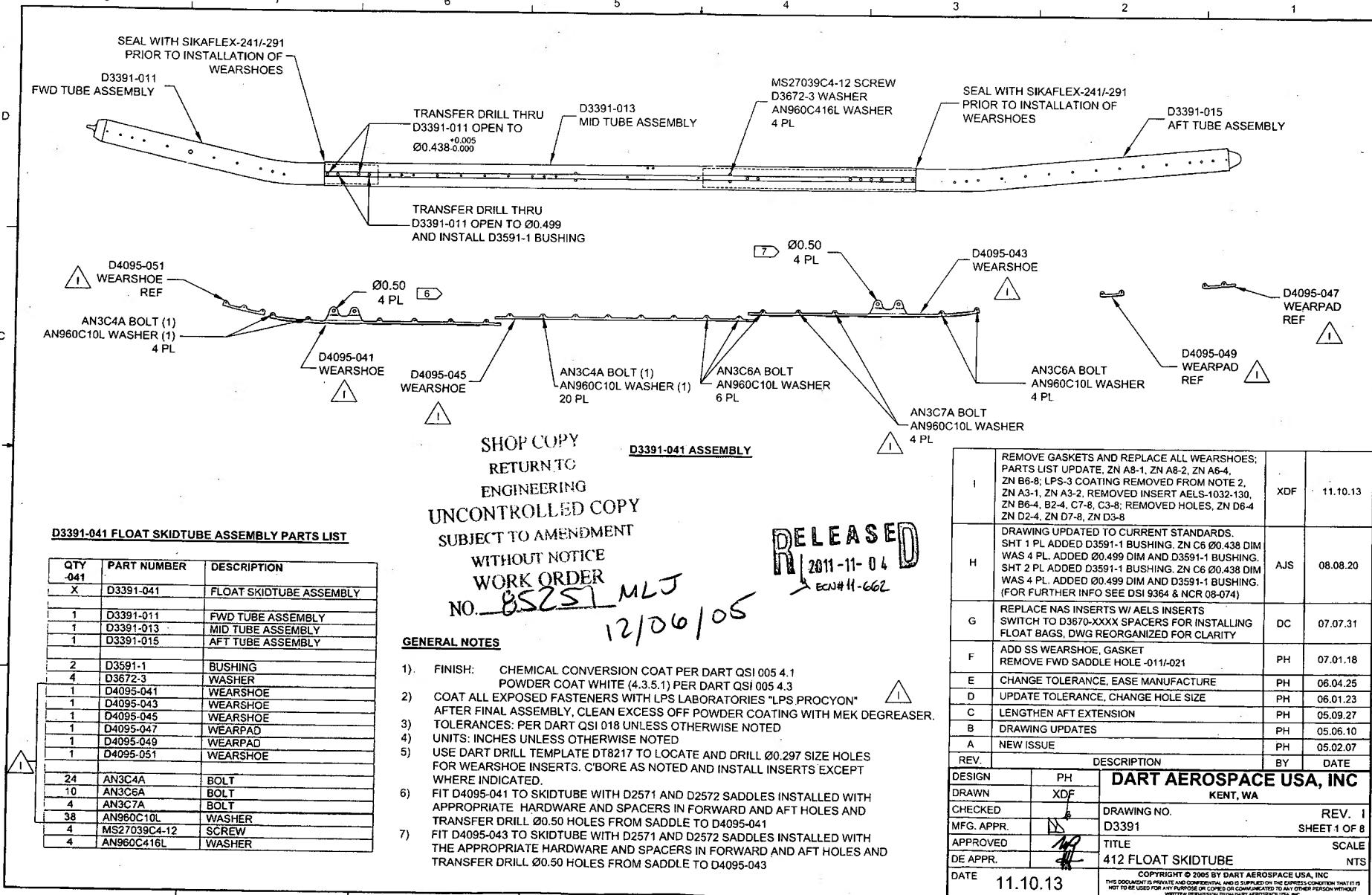
1

\_\_\_\_\_

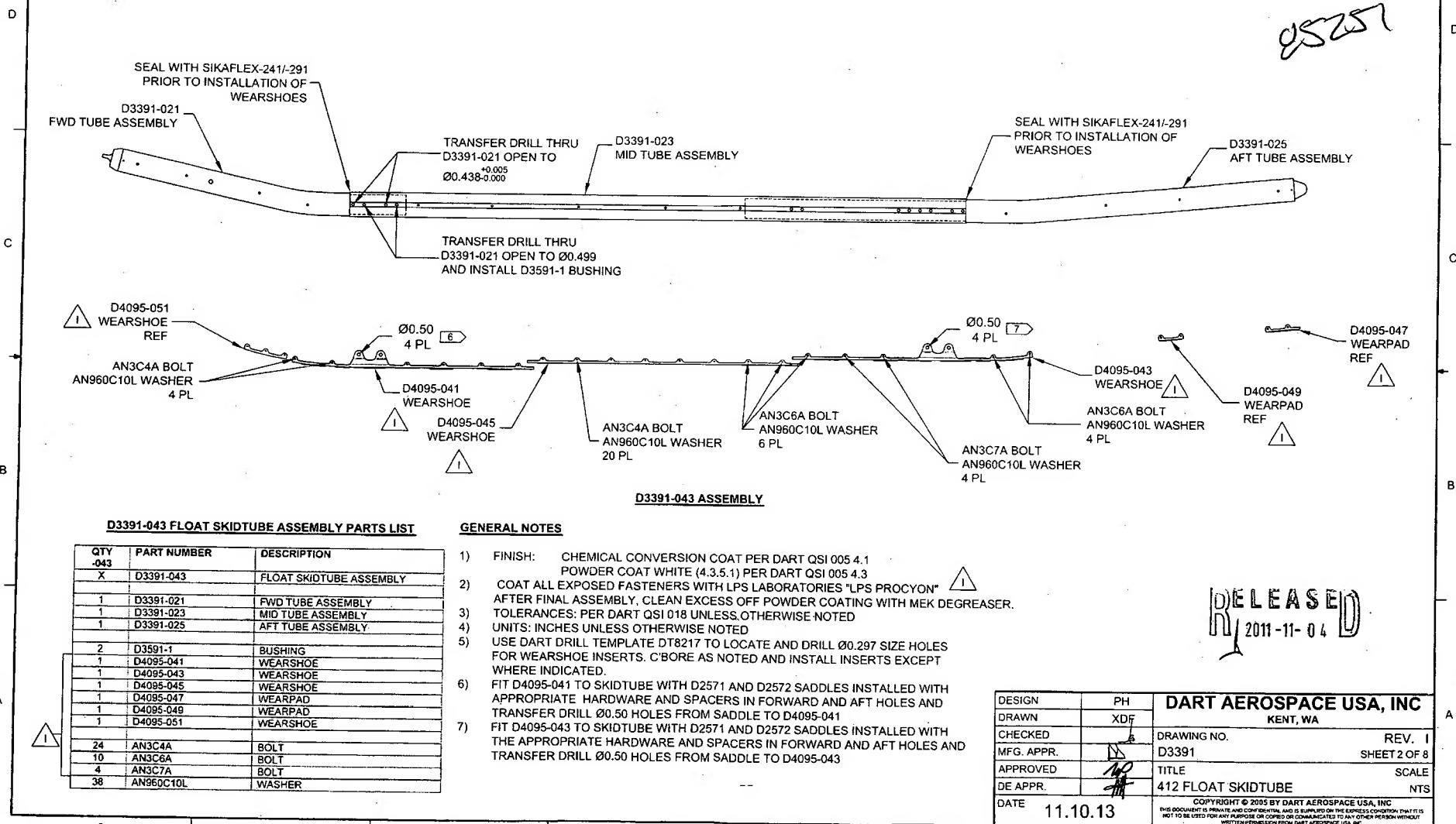
84081

13

Y1

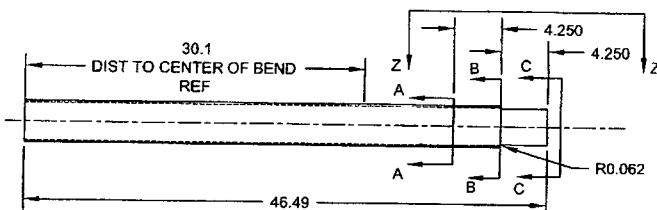


8 1 7 1 6 5 4 3 2 1

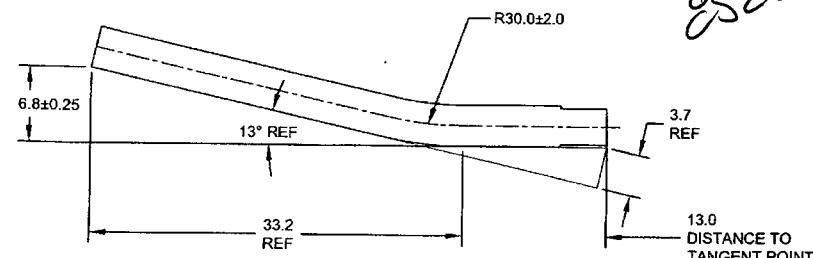


8 7 6 5 4 3 2 1

D

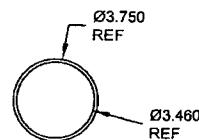


**D3391-1 CUTTING DETAIL**  
(MAKE FROM D6013-047 SKIDTUBE MATERIAL)

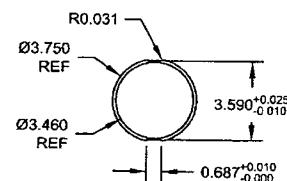


05251

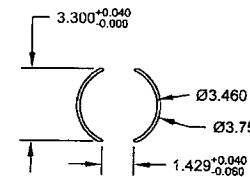
**D3391-011-021 BENDING DETAIL**  
(MAKE FROM D3391-1)



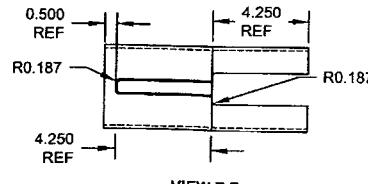
**SECTION A-A**  
SCALE 2X



**SECTION B-B**  
SCALE 2X



**SECTION C-C**  
SCALE 2X



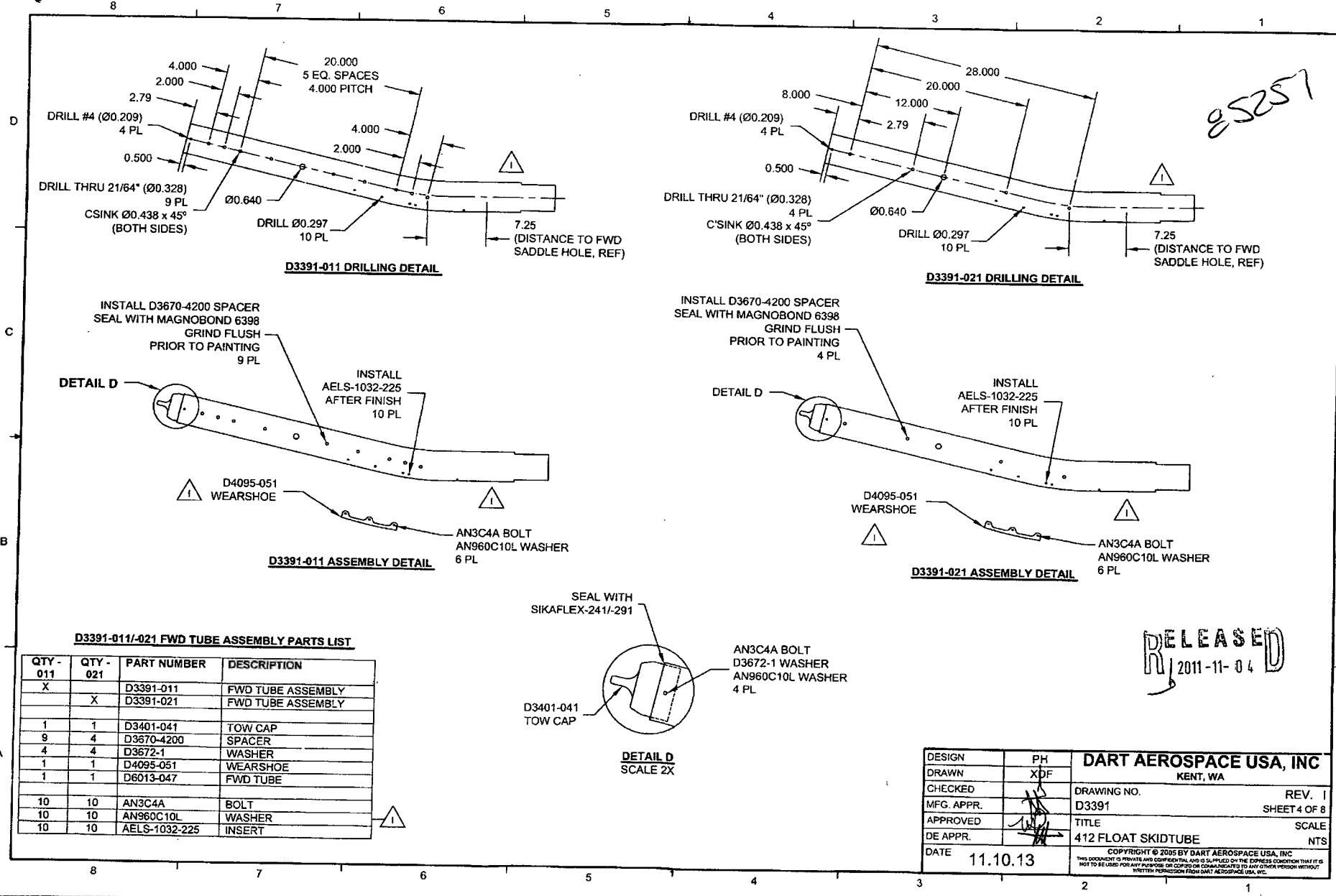
**VIEW Z-Z**  
SCALE 2X

RELEASED  
2011-11-04

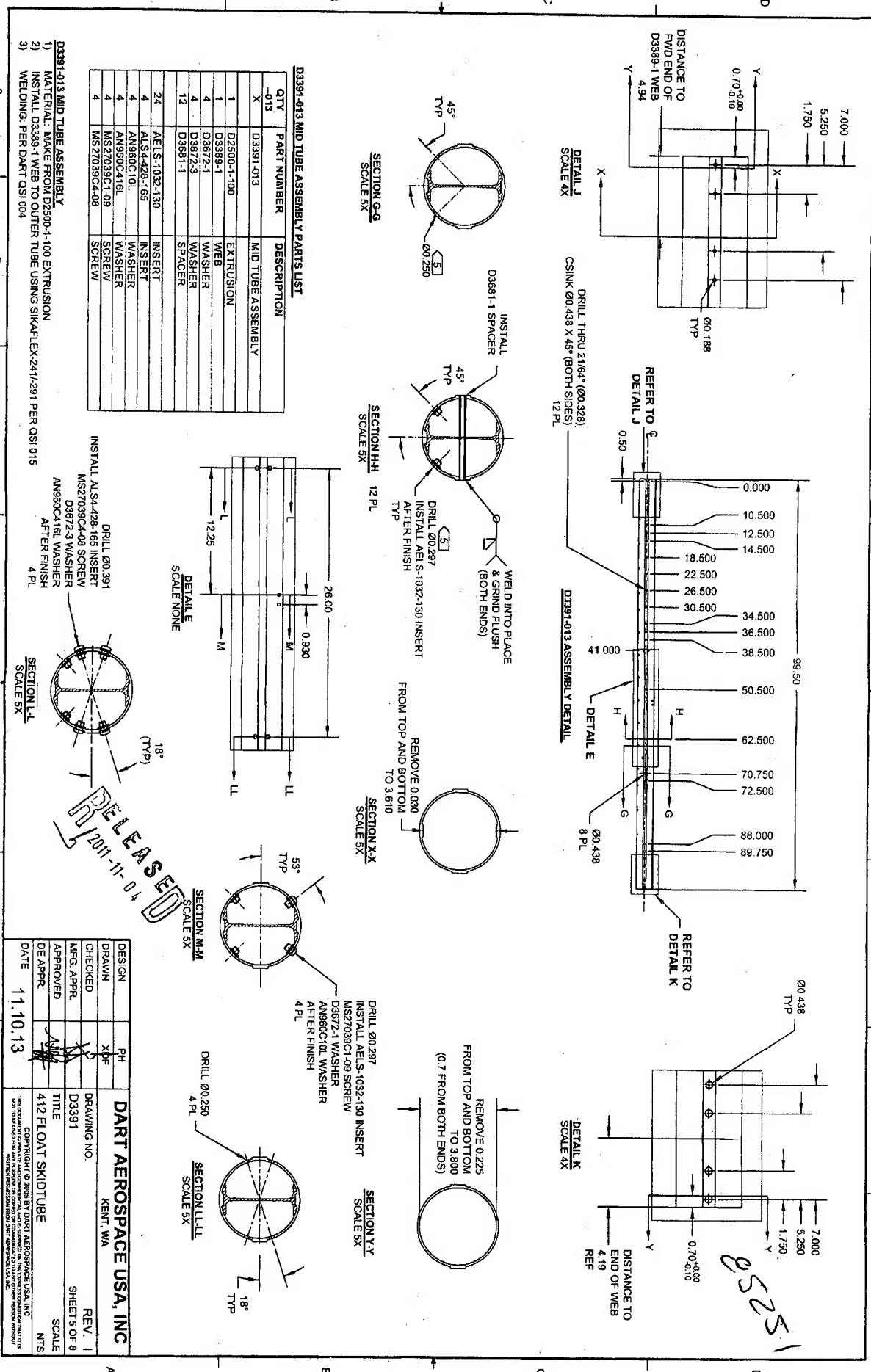
DESIGN	PH	DART AEROSPACE USA, INC
DRAWN	XDF	KENT, WA
CHECKED		DRAWING NO. D3391
MFG. APPR.		REV. 1
APPROVED		SHEET 3 OF 8
DE APPR.		TITLE 412 FLOAT SKIDTUBE
DATE	11.10.13	SCALE NTS

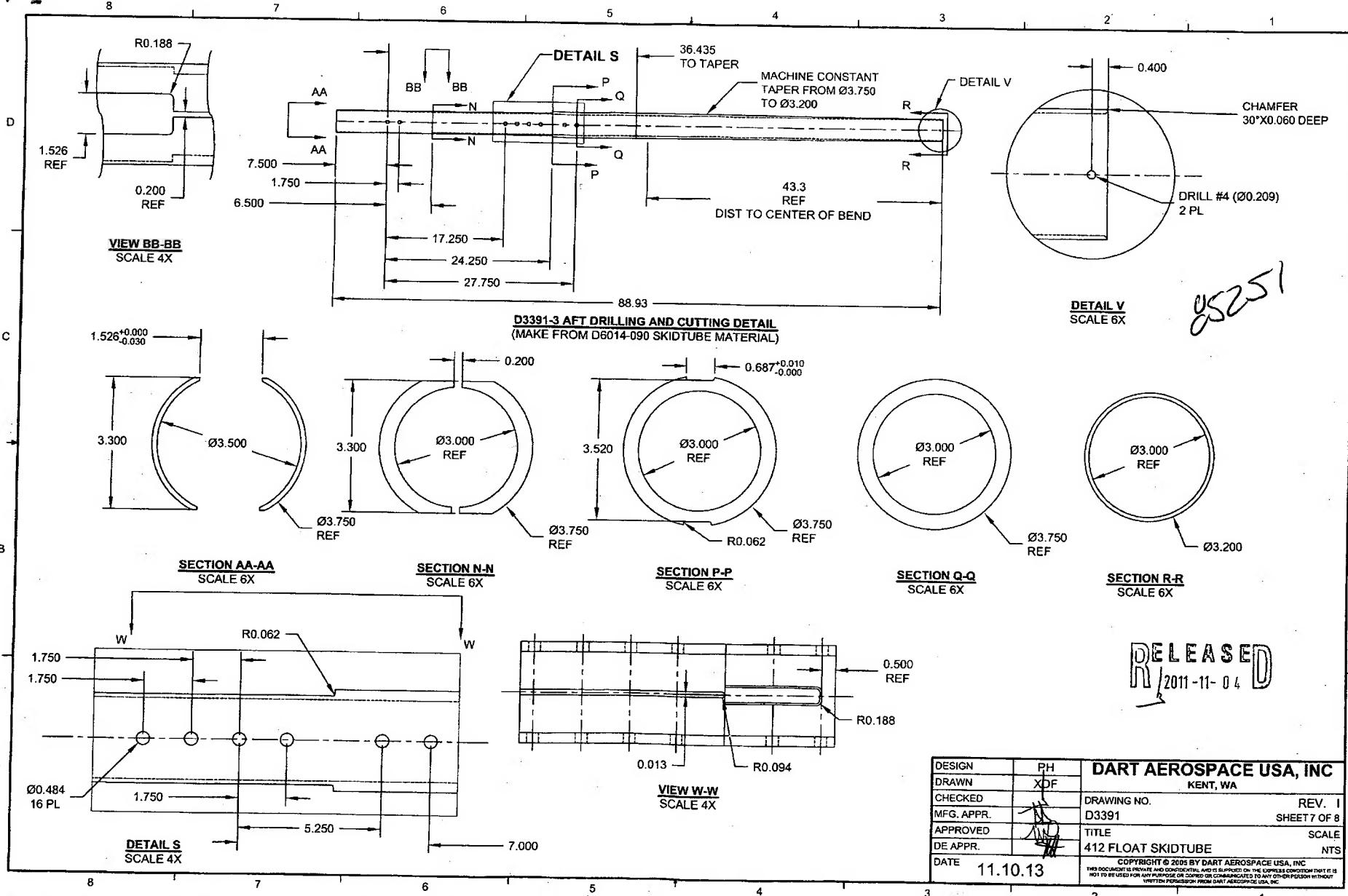
Copyright © 2013 by DART Aerospace USA, Inc.  
This document is private and confidential and is supplied on the express condition that it is  
not to be used for any purpose or copied or communicated to any other person without  
written permission from DART Aerospace USA, Inc.

8 7 6 5 4 3 2 1









RELEASED  
2011-11-04

DESIGN	PH	DART AEROSPACE USA, INC		
DRAWN	XDF	KENT, WA		
CHECKED		DRAWING NO.	REV. 1	
MFG. APPR.		D3391	SHEET 7 OF 8	
APPROVED		TITLE	SCALE	
DE APPR.		412 FLOAT SKIDTUBE	NTS	
DATE	11.10.13	COPYRIGHT © 2005 BY DART AEROSPACE USA, INC		
THIS DOCUMENT CONTAINS TRADES, PROPRIETARY AND CONFIDENTIAL INFORMATION OF DART AEROSPACE USA, INC. IT IS NOT TO BE USED FOR PURPOSES OTHER THAN THE DESIGN, MANUFACTURE, AND OPERATION OF AIRCRAFT.				

